

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-027270**Date Inspected:** 24-Feb-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** Salvador Merino**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

Quality Assurance Inspector (QA) Rene Hernandez was at the American Bridge/Fluor (ABF) job site at Yerba Buena Island in California between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were randomly being observed:

**West Line**

This QA observed, at random intervals, ABF/JV qualified welder Mike Jimenez #4671 performing Shielded Metal Arc Welding (SMAW) with 1/8" diameter E7018H4R electrode and implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-1050A-CU. This was a Complete Joint Penetration (CJP) weld on a 20mm plate insert at the "A" deck to close the lifting lug deck penetration holes. This work was located at 13W PP121.5 W3 3 & 4 was performed in the flat position from the topside of the "A" deck plate. During welding, ABF Quality Control (QC) Salvador Merino was noted monitoring the welding parameters. Welding parameters were recorded. Also verified that CU backup strip was secured from top and under deck.

This QA observed, at random intervals, ABF/JV qualified welder Rick Clayborn #2773 performing Shielded Metal Arc Welding (SMAW) with 1/8" diameter E7018H4R electrode and implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-1110A. This was a Complete Joint Penetration (CJP) weld on a 20mm plate insert at the "A" deck to close the lifting lug deck penetration holes. This work was located at 13W PP121.5 W4 welds 1 & 3 were performed in the overhead position from the bottom side of the "A" deck plate. During welding, ABF Quality Control (QC) Salvador Merino was noted monitoring the welding parameters. Welding parameters were recorded.

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This QA observed, at random intervals, ABF/JV qualified welder Eric Sparks #3040 performing Shielded Metal Arc Welding (SMAW) with 1/8" diameter E7018H4R electrode and implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-1110A. This was a Complete Joint Penetration (CJP) weld on a 20mm plate insert at the "A" deck to close the lifting lug deck penetration holes. This work was located at 13W PP119.5 W3 welds 4 were performed in the overhead position from the bottom side of the "A" deck plate. During welding, ABF Quality Control (QC) Salvador Merino was noted monitoring the welding parameters. Welding parameters were recorded.

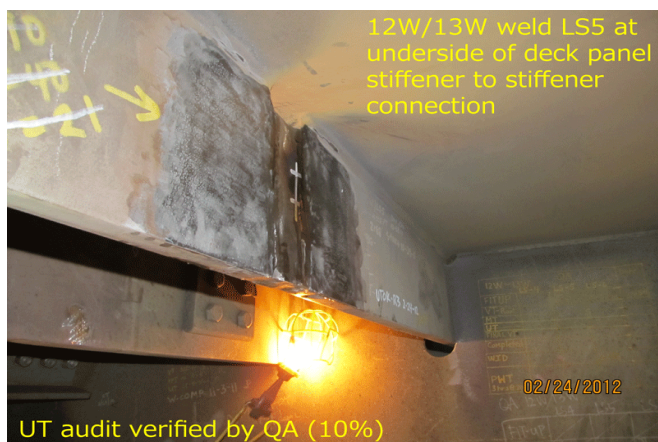
This QA observed, at random intervals, ABF/JV qualified welder Rich Garcia #5892 performing Shielded Metal Arc Welding (SMAW) with 1/8" diameter E9018 electrode and implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-1012-3. This was a Complete Joint Penetration (CJP) weld on a 18mm plate. This work was located at 13W/14W LS6 weld was performed in the vertical position from the topside of the stiffener plate. During welding, ABF Quality Control (QC) Salvador Merino was noted monitoring the welding parameters. Welding parameters were recorded.

### Ultrasonic Testing

This QA performed Ultrasonic Testing (UT) on approximately 10% of welds at the following location and weld numbers: 12W/13W LS5.

These welds were previously accepted by QC Ultrasonic technicians in accordance with AWS D1.5-2002, section 6, table 6.3.

This QA observed no rejectable indications at the time of testing. This QA generated a TL-6027 UT report on this date. The completed work observed at this location appeared to be in compliance with the contract specifications.



### Summary of Conversations:

Pertinent conversations are in the body of this report

### Comments

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This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy, (510) 385-5910, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Hernandez,Rene	Quality Assurance Inspector
<b>Reviewed By:</b>	Levell,Bill	QA Reviewer

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